

Work Order ID 131771

Tuesday, April 21, 2015 1:49:50 PM

131771

Page 1

Item ID: D3651-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Base Assembly
 Start Date: 4/20/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MJS Date: 1504-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B ✓								
100	Pick Kit	0.00							
100						2	FF		AUG 27 2015
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
110						2	FF		AUG 31 2015
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per dwg D36512- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651Batch: <u>M1320213</u> -install + 133071 D3651-1 using 3M high per formance contact adhesive 1357 as per dwg D3651Batch: <u>M127394</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
SEP 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/20/15 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 4/20/15 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: 62

0.00

130

Packaging

Memo

0.00

Packaging

LOCATION : GA

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

SEP 03 2015

15/9/30

120150903

5th

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 131771

131771

Parent Item: D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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CR3523-4-02

Purchased

No

100

Each

465.0000

58

116

CR3523-4-02

RIVET

FF

JUN 02 2015

Location

Loc Qty

Loc Code

GA

226

m130415

56

m131803

170

ST318

239

m130415

39

m131340

200

D3651-043

Manufactured

No

110

Each

3.0000

1

2

D3651-043

Flange Weldment

FF

JUN 02 2015

Location

Loc Qty

Loc Code

ST227

3

126823

3

D3651-1

Manufactured

No

110

Each

5.0000

1

2

D3651-1

Gasket

FF

JUN 02 2015

Location

Loc Qty

Loc Code

ST227

5

126523

5

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Picklist Print

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Parent Item: D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

D3651-11 Manufactured No

110 Each 2.0000 1 2

D3651-11

Gasket

**

FF

JUN 02 2015

Location

Loc Qty

Loc Code

ST227

2

128231

2

2

D3651-13 Manufactured No

110 Each 4.0000 1 2

D3651-13

Outside Doubler

**

FF

JUN 02 2015

Location

Loc Qty

Loc Code

GA

1

95404

1

ST227A

3

128232

3

2

D3651-9 Manufactured No

110 Each 3.0000 1 2

D3651-9

Inside Doubler

**

FF

JUN 02 2015

Location

Loc Qty

Loc Code

ST227A

3

128233

3

2

DQA: _____ Date: _____



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